



Dart Aerospace Ltd.
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RBW5305G81851-3G-1
Job Sheet 184934



5743
moved to Nov 29

Part No: RBW5305G81851-3G-1

Job Qty: 2 ea

Part Name: Right Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/18/18

Job Tracking No:

Due Date: 10/26/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW5305G81851-3G REV 1D IPP REV A 18.05.28 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	10/26/18	10/26/18	0.00	0.00	Start Up Large Fab-1		a
110	Large Fab	2 pcs	10/26/18	10/26/18	0.00	4.00	Large Fab 2		EL
115	QC	2 pcs	10/26/18	10/26/18	0.00	0.00	QC9		SL
120	QC	2 pcs	10/26/18	10/26/18	0.00	0.00	QC5		SL
122	Small Fab	2 pcs	10/26/18	10/26/18	0.00	0.33	Small Fab-3		AP
124	Mill Conv	2 pcs	10/26/18	10/26/18	0.00	0.33	Mill Conv 2		PROD 18-12-27
126	QC	2 pcs	10/26/18	10/26/18	0.00	0.00	QC2 Machining-3		PROD 18-12-27
128	QC	2 pcs	10/26/18	10/26/18	0.00	0.00	QC8 Machining-3		18-17-27
138	Powdercoat	2 pcs	10/26/18	10/26/18	0.00	0.20	Powdercoat6		DEC 18-12-27
140	QC	2 pcs	10/26/18	10/26/18	0.00	0.00	QC3		DEC 2 8 2018 68
180	Packaging	2 pcs	10/26/18	10/26/18	0.00	0.00	Packaging3		DEC 2 8 2018 70
190	QC21-FG	2 Ea	10/26/18	10/26/18	0.00	0.00	QC21		DEC 2 8 2018 70

Part Op 110 - Weld as per DWG.

Descriptions: 122 - 1- Load test each weldment at 750-800 lbs.

124 - 1- Skim bottom after welding as per DWG

138 - START TIME: 10:30 OVEN TEMPERATURE: 320° FINISH TIME: 11:00

Job BOM

007043

Part / Item	Component Name	Quantity	Operation	Container
RBW5305G81851-3G-3	Right Tab	2 Ea (1 ea)	90-Start up Operation	5118182
RBW5305G81851-3G-5	Plate	2 Ea (1 ea)	90-Start up Operation	5120370



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CANADA
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Container No: S137360



Part: RBW5305G81851-3G-1

Job No: 184934

Serial No/Batch: S137360

Revision: B

Inspector:

Exp Date:

Instructions:

Date: 12/12/18

ns	Required	Inventory	Allocated
5000	2	8	0
5	2	0	0

ons

Specifications could not be found.

Plex 10/18/18 11:31 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

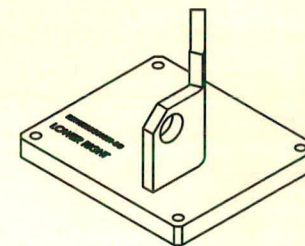
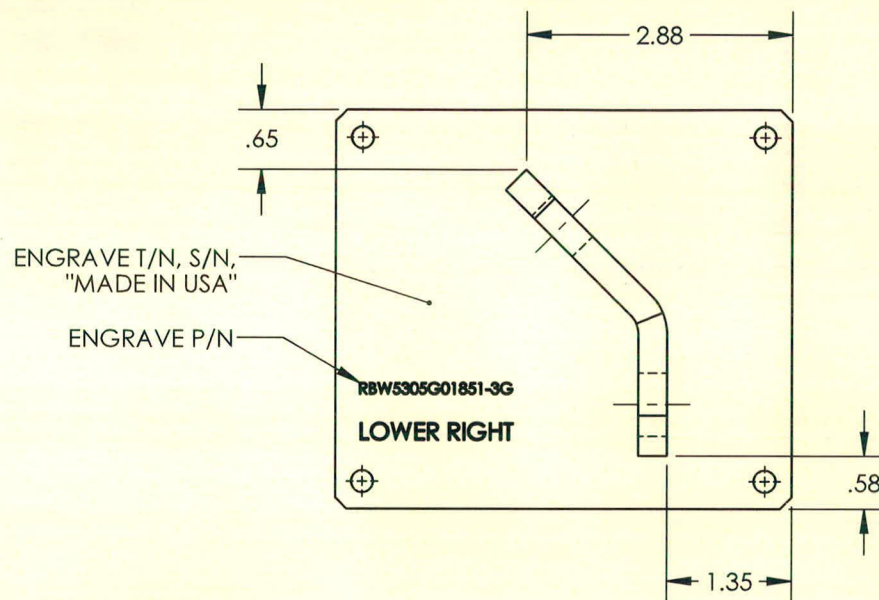
QA Closed: _____ Date: _____

Work Order update only ☐

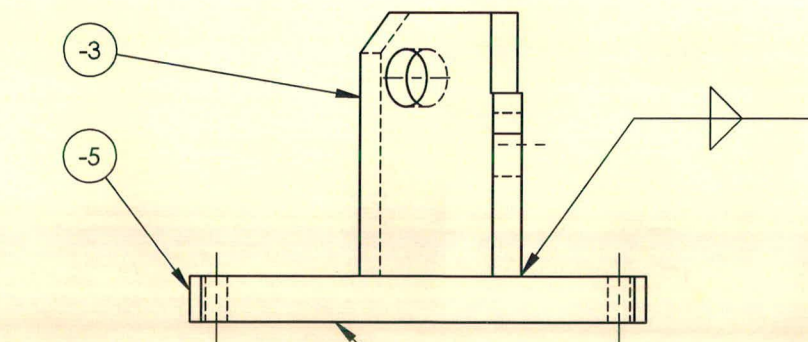
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
1D	-1 CH'D FINISH WAS POWDER COAT FORREST #T-3370 S9 RED WAGON IS POWDER COAT RED RAL 3000.	7/2/2014	DPD
			RJC



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 184934 mcs
1870-18



SKIM BOTTOM AFTER WELDING

(-1)
RIGHT WELDMENT

DART AEROSPACE	
TITLE T/B LIFT FITTINGS	
DWG NO. RBW5305G81851-3G-1	REV 1D
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 .X ± .1	DRAWN BY: DUERFELDT APPROVED: D Weid HEAT TREAT FINISH POWDER COAT RED SPEC RAL 3000 USED ON MODEL AW139
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 6/17/2014
SHEET 2 OF 6	

DART AEROSPACE LTD

Work Order:	184934
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Description: Right WELDMent

Part Number:	RBW 5305681851-36-1
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Inspection Dwg: as Per Rev: 1/1

Page 1 of 1

INSPECTION SHEET

[illegible]

Measured by:	Fred	Checked by:	B.A.	QC Inspector:	
Date:	18-12-27	Date:	18-12-27	Date:	

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

